

Date: Monday, 8/21/2006 2:12:07 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
<b>Job Number</b> :	28261	<b>Part Number</b> :	D29322
<b>Estimate Number</b> :	10832	<b>Drawing Number</b> :	D2932 REV B
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A
<b>This Issue</b> :	8/21/2006	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	N/A
<b>First Issue</b> :	N/A	<b>Due Date</b> :	9/10/2006
<b>Previous Run</b> :	27364	<b>Qty:</b>	8 Um: Each
<b>Written By</b> :	[Signature]		
<b>Checked &amp; Approved By</b> :	[Signature]		
<b>Comment</b> :	Est: B 00.06.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

7075-T7351 2X6.25X7.875



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: 1325348

SD 06.09.05

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

5-Deburr

JL / SD 06.09.05

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06.09.05

4.0

QC1




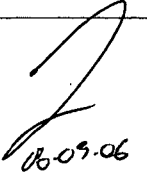

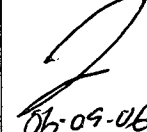

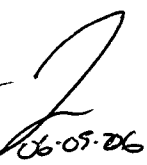

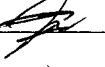

INSPECT ALL DIM TO DIM SHEET



**Comment:** INSPECT ALL DIM TO DIM SHEET

JL / SD 06.09.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-09-06	20	2 saddles have a line grinded .005 deep from the chamfer tw! 1st machinist had changed the offset. Marks are along the bottom of saddle on the outside. First 2 parts off machine.		Minor tool marks. Parts acceptable. Re-adjust offset.	SA 06-09-06			
06-09-06	20	Wrong offset changed, causing 2 saddle holes to be drilled out side by side. At the bottom of the saddle. operator error.		Scrap; destroy; replace.	J.L. 06/09/07			
								

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/08/14

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 8/21/2006 2:12:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 28261

Part Number: D29322

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ML 06/09/07*

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Q.M 06-09-08*

8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Q.M 06-09-12*

8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC 06 09 12*

8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST474*

*PB 06/09/14*

8

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*P 06/09/14*

8

Job Completion



*U 06-09-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28261
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2932-2
<b>Inspection Dwg:</b> D2932 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.118	.118	.121		
B	0.100	0.140		.119	.118	.118	.120		
C	0.100	0.140		.120	.120	.119	.120		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.551	.550	.548	.547		
P	0.490	0.510		.499	.498	.499	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.247	.248	.247		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.136	1.137	1.136	1.140		
Y	1.565	1.585		1.574	1.575	1.574	1.576		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L. / S.A.
Date:	06.09.07

Audited by:	cm
Date:	06/09/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28261
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2932-2
<b>Inspection Dwg:</b> D2932 Rev. B	<b>Page 1 of 1</b>

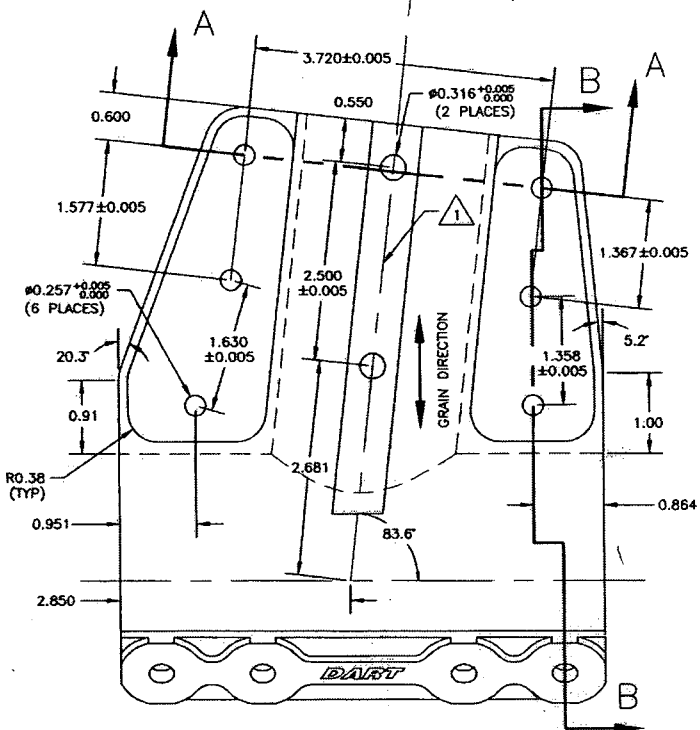
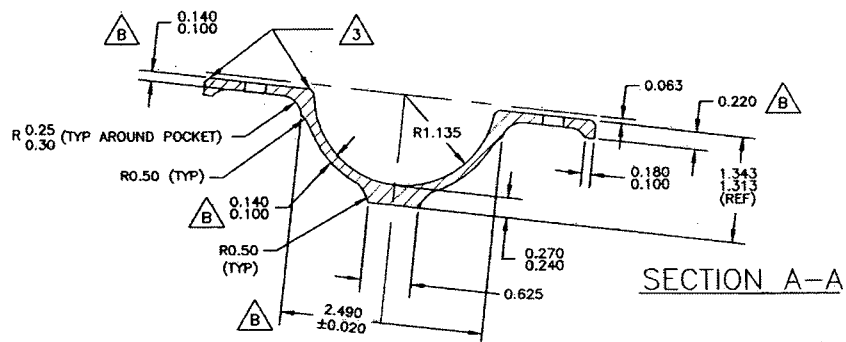
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.115	.115	.115	.115		
B	0.100	0.140		.120	.120	.115	.115		
C	0.100	0.140		.119	.120	.120	.120		
D	0.210	0.230		.224	.224	.223	.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.123	.123	.124	.124		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.495	.497	.497	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.247	.247	.249	.249		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.137	1.136	1.137	1.136		
Y	1.565	1.585		1.575	1.574	1.575	1.574		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

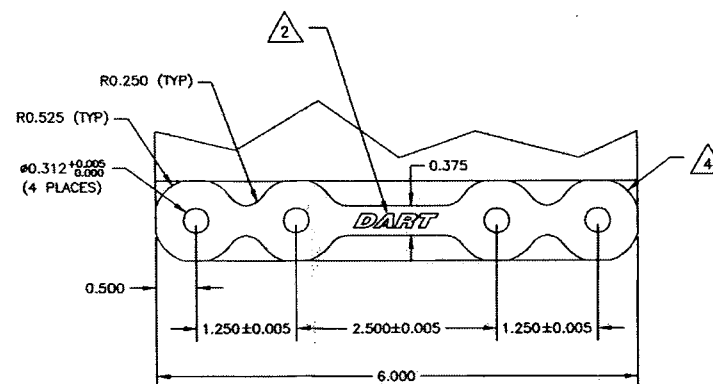
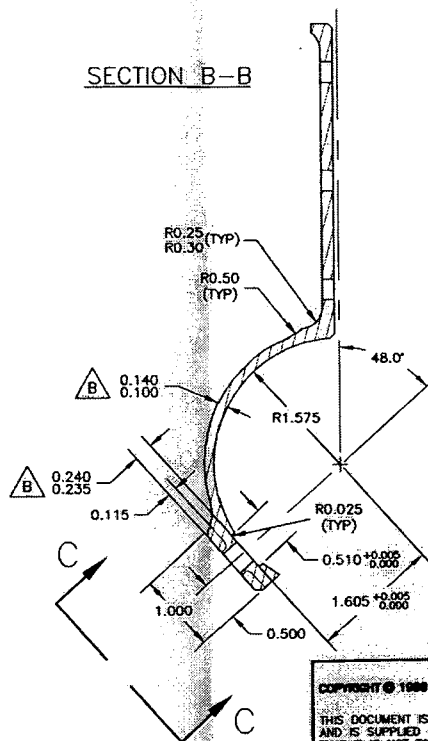
Measured by: SA
Date: 06.09.05

Audited by: gml
Date: 06/09/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED  
00.05.31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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